

Ship Jan 15

Work Order ID 89508

89508

Page 1

August-24-12 9:44:06 AM

Item ID: D4640-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector

Start Date: 8/24/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/05/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4640

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg

Prog Rev: *C*

Dwg Rev: *C*

Deburr as required

Trimmed 100

TRIMMED

(10)

B13-1-3

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(10)

B13-1-3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 89508

89508

Page 2

August-24-12 9:44:06 AM

Item ID: D4640-11 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Floor Protector
Start Date: 8/24/12 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 11/05/12 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo Use template to make barcodes 13.1.03	0.00 0.00				10			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	DRR 8960			10		13/01/04 SD	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						13/11/10 JF	

13-01-4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____ _____
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Picklist Print

August-24-12 9:44:06 AM

Page 1

Work Order ID: 89508

Parent Item: D4640-11

Start Date: 8/24/12

Required Date: 11/05/12

Parent Item Name: Floor Protector

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	1,452.6700	10.79	113.57895	160. 13-1-3		

Location

Loc Qty

Loc Code

therm

1452.67

112176

40.44

114459

1412.23

123105

10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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DART AEROSPACE LTD		Work Order: 89508
Description: Floor Protector		Part Number: D4640-11
Inspection Dwg: D4640	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	✓		T Bx1	
25.42	+/-0.030	25.47	✓		T	
27.86	+/-0.030	27.86	✓		T	
31.36	+/-0.030	31.36	✓		T	
49.96	+/-0.030	49.96	✓		T	
53.46	+/-0.030	53.46	✓		T	
55.90	+/-0.030	55.90	✓		T	
62.11	+/-0.030	62.11	✓		T	
63.61	+/-0.030	63.61	✓		T	
73.08	+/-0.030	73.08	✓		T	
76.55	+/-0.010	76.55	✓		T	
78.05	+/-0.030	78.05	✓		T	
80.80	+/-0.030	80.80	✓		T	
0.88	+/-0.030	0.88	✓		T	
4.21	+/-0.030	4.21	✓		T	
5.02	+/-0.030	5.02	✓		T	
8.59	+/-0.030	8.59	✓		T	
10.65	+/-0.030	10.65	✓		T	
14.22	+/-0.030	14.22	✓		T	
15.03	+/-0.030	15.03	✓		T	
17.62	+/-0.030	17.62	✓		T	
0.37	+/-0.030	0.37	✓		T	
1.84	+/-0.030	1.84	✓		T	
3.67	+/-0.030	3.67	✓		T	
3.76	+/-0.030	3.76	✓		T	
4.59	+/-0.030	4.59	✓		T	
8.59	+/-0.030	8.59	✓		T	
10.65	+/-0.030	10.65	✓		T	
14.64	+/-0.030	14.64	✓		T	
15.48	+/-0.030	15.48	✓		T	
15.57	+/-0.030	15.57	✓		T	
17.40	+/-0.030	17.40	✓		T	
18.87	+/-0.030	18.87	✓		T	
19.24	+/-0.030	19.24	✓		T	
0.093	+/-0.010	0.094	✓		V Bx2	

Measured by: B	Audited by: [Signature]	Preliminary Approval:
Date: 12-1-3	Date: 12/1/03	Date:

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	[Signature]

NCR: Yes / No

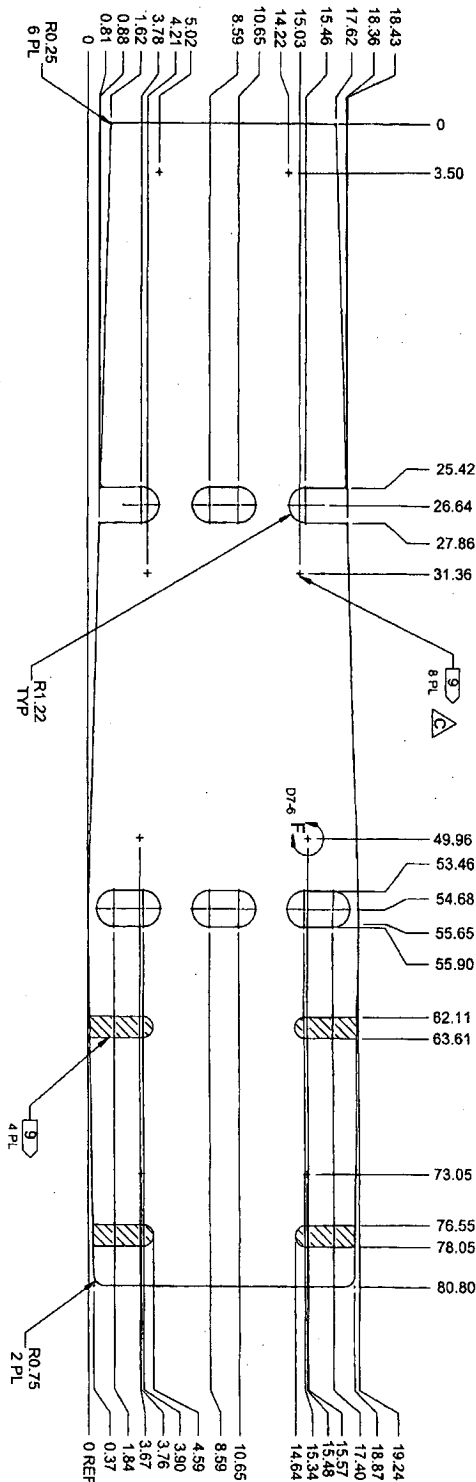
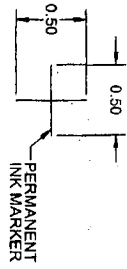
WORK ORDER NON-CONFORMANCE / UPDATE

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DETAIL F
NOT TO SCALE
TRIMMED KIT ONLY



D4640-11 FLOOR PROTECTOR
TEXTURED SIDE SHOWN

- NOTES:
- 1) MATERIAL: F6006-GY58133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER OSI 044 6.1 ON SMOOTH SIDE
 - 7) WEIGHT: 5.68 LBS (TRIMMED WEIGHT = 5.55 LBS)
 - 8) CHECK PER TEMPLATE DT8929
 - 9) IF CUSTOMER REQUESTS - TRIMMED KIT - ON PURCHASE ORDER - DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER - TRIM AND REMOVE SHADED AREA

89508

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR		
APPROVED		
DATE	12.11.22	
TITLE		BAGGAGE PROTECTOR
SCALE		NTS

RELEASED
2012-11-29
JW